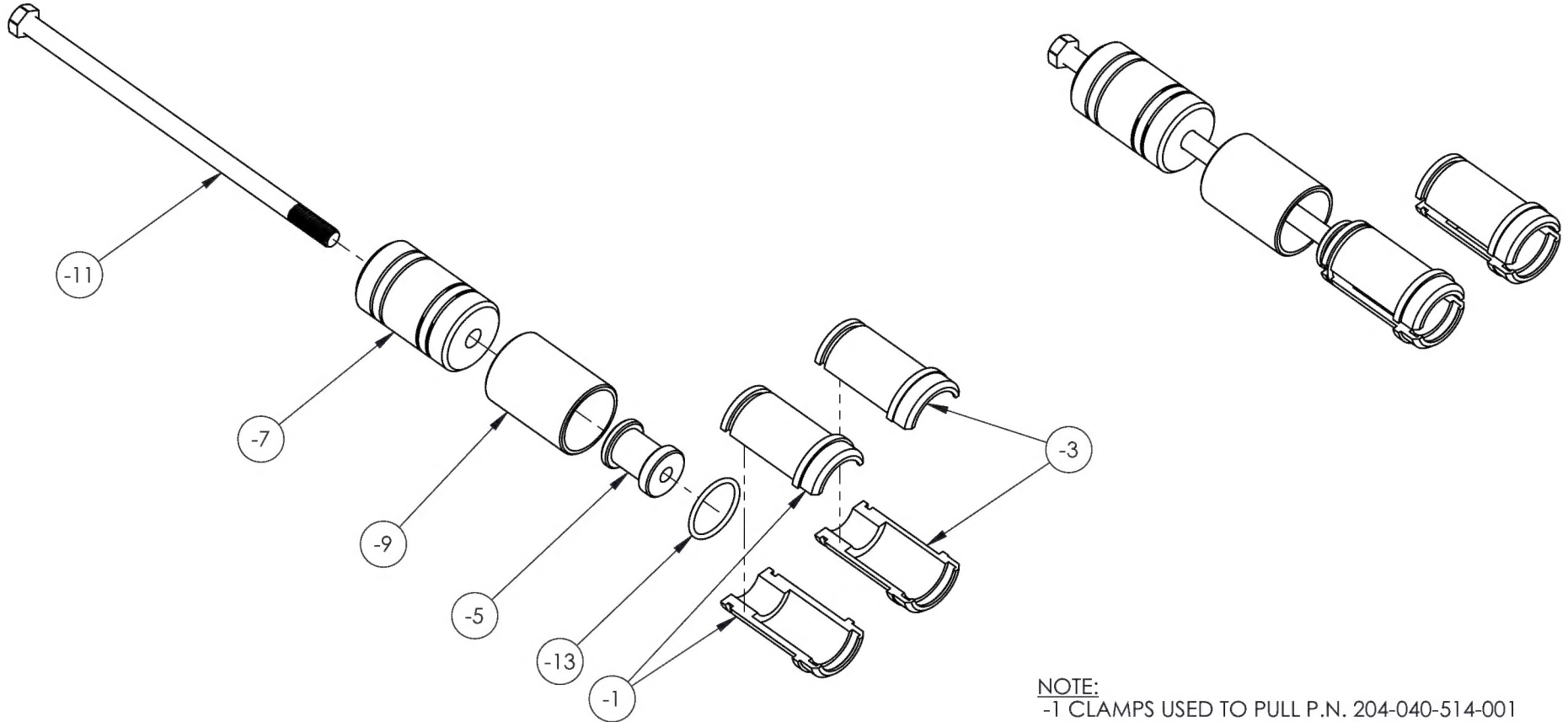


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	UPDATED TO NEW STANDARD. -1, -3, -5, -7 CH'D MAT'L WAS 1018 IS 1018/1020 CR. -1, -3, -5, -7, -9 ADDED FINISH SPEC. -1, -3 ADDED ENGRAVE NOTE. -7 CH'D NOTE WAS ENGRAVE P/N, S/N, & "MADE IN USA" IS ENGRAVE T/N, S/N, & "MADE IN USA".	8/15/2016	DEW	SM



NOTE:  
-1 CLAMPS USED TO PULL P.N. 204-040-514-001  
-3 CLAMPS USED TO PULL P.N. 412-340-416-101

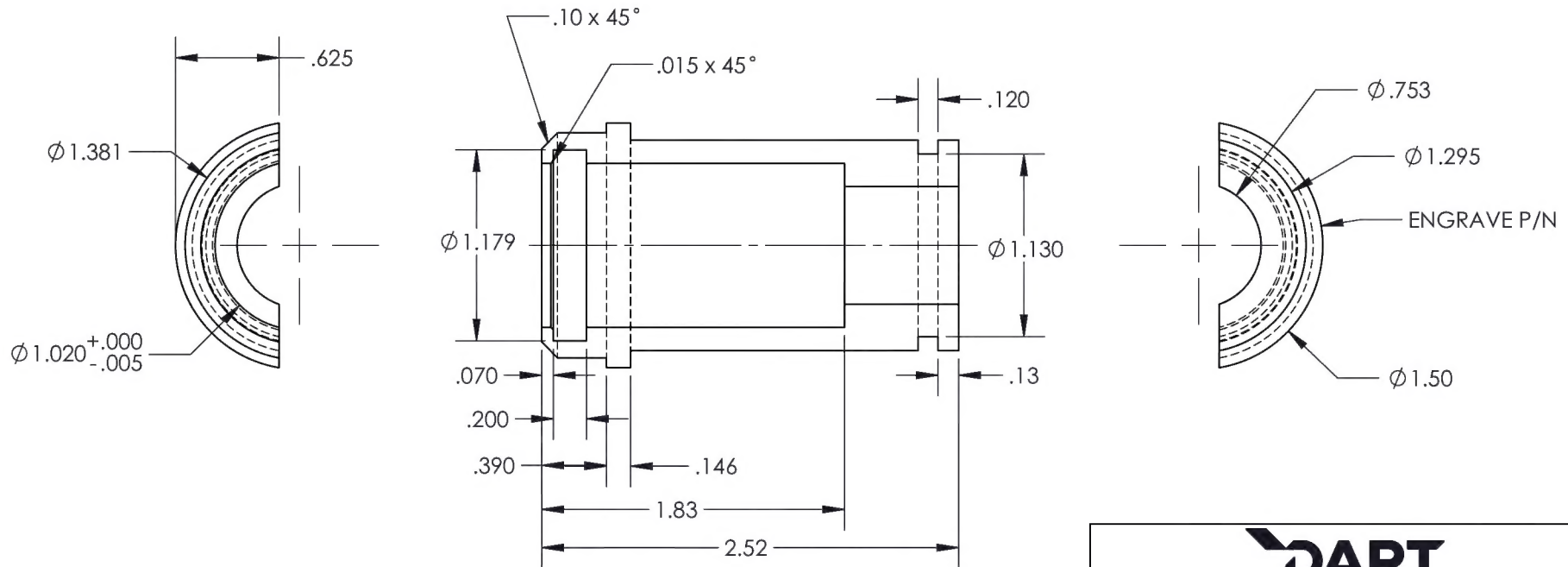


TITLE	
SIGHT GLASS PULLER	
DWG NO.	RBT18552
REV	2
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY:	GILBERT
CHECKED:	DUERFELDT
OPPS APPR:	ANDERSON
QA APPR:	LINDSAY
APPROVED:	MACKOVJAK
SCALE	1:3
DATE	11/12/2011
SHEET 1 OF 6	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	2	HALF CLAMP	1018/1020 CR		2
			-3	2	HALF CLAMP	1018/1020 CR		3
			-5	1	SPOOL	1018/1020 CR		4
			-7	1	SLIDE	1018/1020 CR		5
			-9	1	BUSHING	STEEL		6
		B/O	-11	1	BOLT	STEEL	3/8-16 X 8 (MCMASTER-CARR #91247A652)	1
		B/O	-13	1	O-RING	BUNA-N	3/32X Ø1-5/16 OD (MCMASTER-CARR #4198T181)	1
		B/O	-15	1	PISTOL CASE	PLASTIC	#10137	NS

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	-1 ADDED SPEC. ADDED ENGRAVE NOTE. CH'D MAT'L WAS 1018 IS 1018/1020 CR.	8/15/2016	DEW	SM

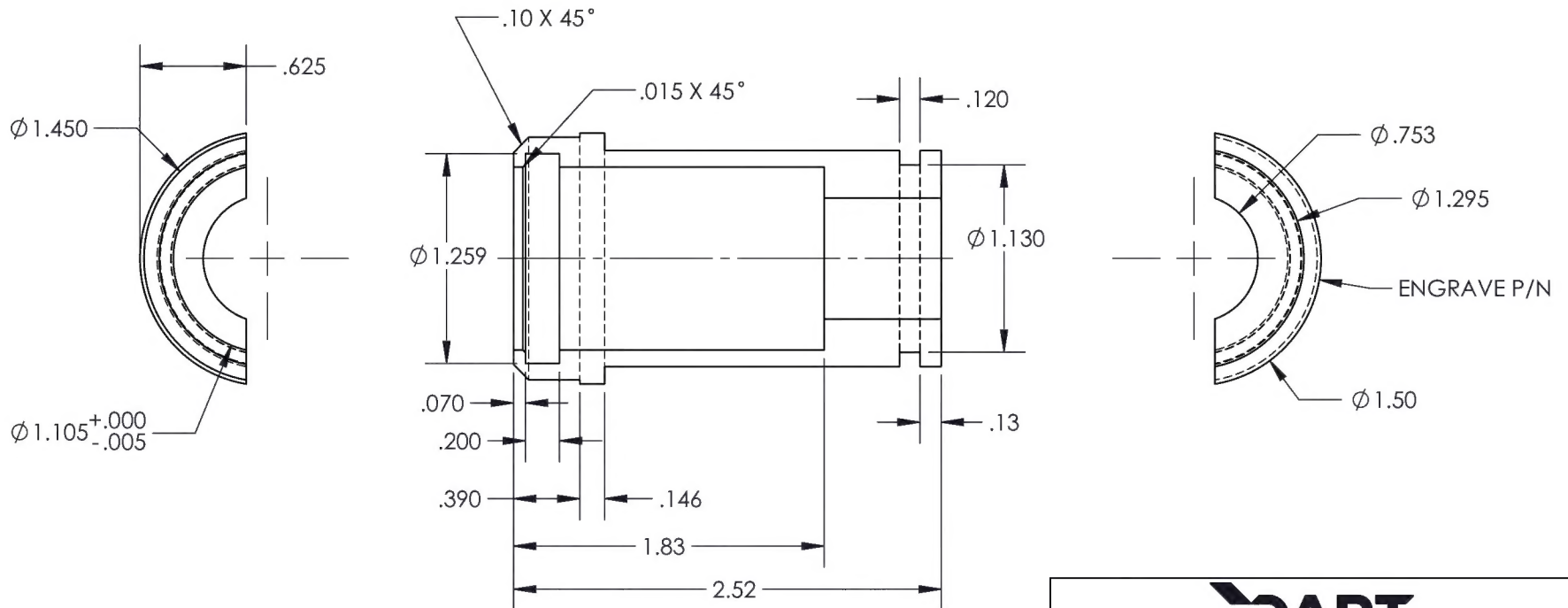


(-1)  
HALF CLAMP

<b>DART AEROSPACE</b>	
TITLE <b>SIGHT GLASS PULLER</b>	
DWG NO. <b>RBT18552-1</b>	REV <b>2</b>
MAT'L 1018/1020 CR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: <b>GILBERT</b>	USED ON MODEL
CHECKED: <b>DUERFELDT</b>	<b>BELL</b>
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	
APPROVED: <b>MACKOVJAK</b>	
SCALE <b>1:1</b>	DATE <b>11/12/2011</b>
SHEET 2 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	-3 ADDED SPEC. ADDED ENGRAVE NOTE. CH'D MAT'L WAS 1018 IS 1018/1020 CR.	8/15/2016	DEW	SM

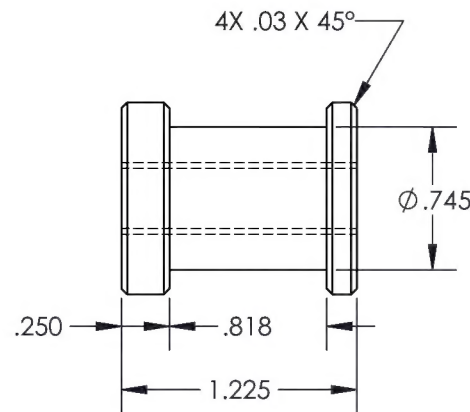
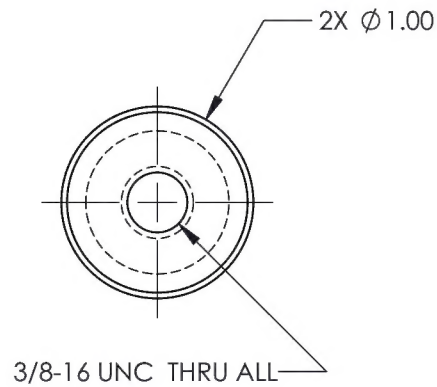
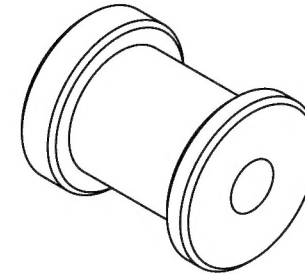


(-3)  
HALF CLAMP

<b>DART AEROSPACE</b>	
TITLE <b>SIGHT GLASS PULLER</b>	
DWG NO. <b>RBT18552-3</b>	REV <b>2</b>
MAT'L 1018/1020 CR TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 1/8 .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: DUERFELDT	BELL
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:1	DATE 11/12/2011
SHEET 3 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	-5 ADDED SPEC. CH'D MAT'L WAS 1018 IS 1018/1020 CR.	8/15/2016	DEW	SM

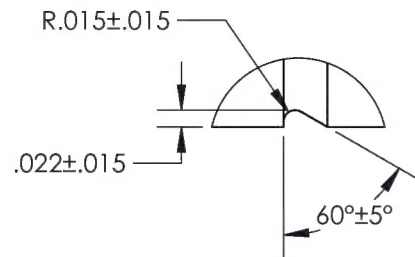
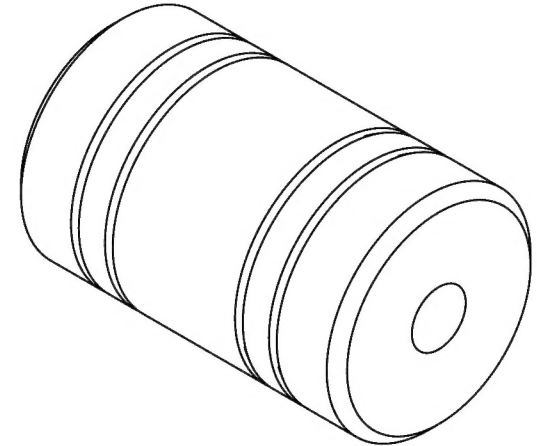
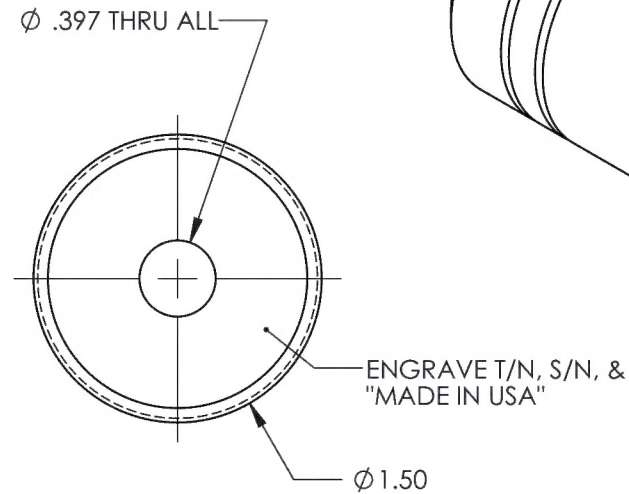
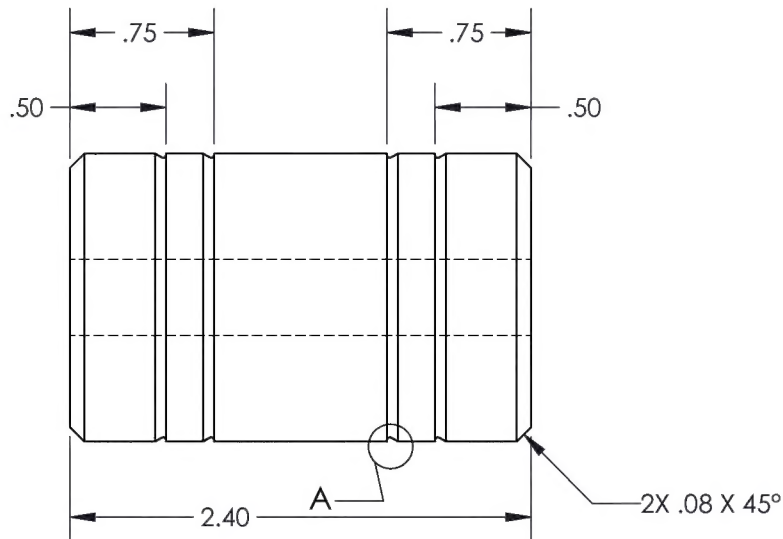


(-5)  
SPOOL

<b>DART AEROSPACE</b>	
TITLE <b>SIGHT GLASS PULLER</b>	
DWG NO. <b>RBT18552-5</b>	REV <b>2</b>
MAT'L 1018/1020 CR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: DUERFELDT	BELL
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:1	DATE 11/12/2011
SHEET 4 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	-7 CH'D NOTE WAS ENGRAVE P/N, S/N, & "MADE IN USA" IS ENGRAVE T/N, S/N, & "MADE IN USA". ADDED SPEC. CH'D MAT'L WAS 1018 IS 1018/1020 CR.	8/15/2016	DEW	SM



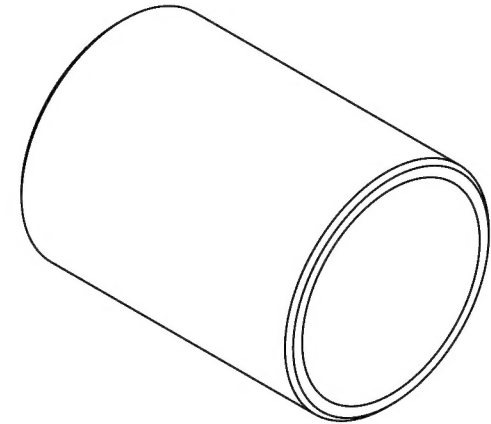
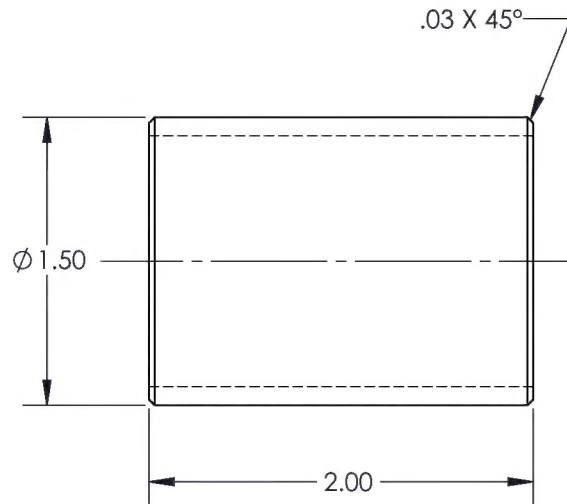
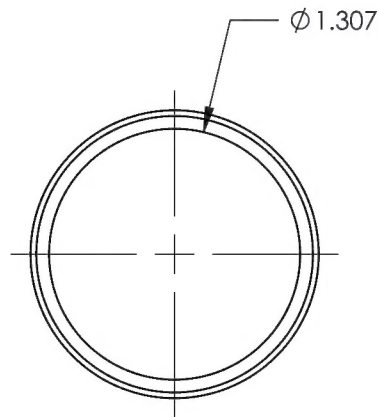
DETAIL A  
SCALE 4 : 1

⑦  
SLIDE

<b>DART AEROSPACE</b>	
TITLE <b>SIGHT GLASS PULLER</b>	
DWG NO. <b>RBT18552-7</b>	REV <b>2</b>
MAT'L 1018/1020 CR HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° ✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: DUERFELDT	BELL
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:1	DATE 11/12/2011
SHEET 5 OF 6	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
2	16-0119	-9 ADDED SPEC.	8/15/2016	DEW	SM



(-9)

BUSHING

<b>DART</b> AEROSPACE	
TITLE SIGHT GLASS PULLER	
DWG NO. RBT18552-9	REV 2
MAT'L STEEL HEAT TREAT FINISH BLACK OXIDE SPEC QMSI-6.2.2, B.O. REV D	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: GILBERT	USED ON MODEL
CHECKED: DUERFELDT	BELL
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: MACKOVJAK	
SCALE 1:1	DATE 11/12/2011
SHEET 6 OF 6	